

Date: Friday, 11/18/2005 3:18:54 PM
User: Linda Laeelle

Process Sheet

SPLIT

u

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 24840 - 2	Part Number	: D2574
Estimate Number	: 10534	Drawing Number	: D2574 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/18/2005 S.O. No. : N/A	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 12/20/2005
Previous Run	: 244341	Qty:	6 (10) 12 Um: Each
Written By	: SEE COMMENT BELOW		
Checked & Approved By	: SEE COMMENT BELOW		
Comment	: Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101005	7075-T7351 8.25X5.0X2.5
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: B21817A (4x)

B21801

MS 06/01/08

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No B24840 Double check by: En 06/01/04

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

- J.G
- MS 06/01/09- J.G
- MS 06/01/09- J.G
- MS 06/01/09PTC
2

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574



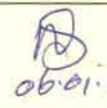

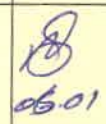
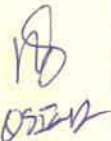


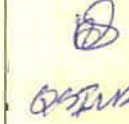
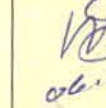
- J.G

- MS 06/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/13	# 2.2	one part SCRAP. origin was of "09.0.100" r1 second op.		Scrap and Destroy and Replate (Fix origin)	 06/01/14	 06.01.14		 06.01.14
06/01/13	# 2.2	one part SCRAP. offset for chamber root was set way too low		Scrap and Destroy and Replate	 06/01/14	 06.01.14		 06.01.14

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 3:18:54 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 24840

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



-J.G
-M8 06/01/09

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/01/13

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06 01 14

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 01 17

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MM 06 01 17

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 373

CX 06/01/18

(6)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

595 06/01/19 (6)

SP 06/01/19 (6)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

□□□□□□□□

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	: 0024840	Department Code:	
Project Name	: D2574	Burden Flags	: NNNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2574	Invoice Number	:
Description	: Saddle, Aft, In	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 12	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	:	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Aft Inboard		Part Number: D2574	
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	✓	✓	✓		
B	1.745	1.755		1.754	1.752	1.750	1.750		
C	3.495	3.505		3.501	3.500	3.505	3.501		
D	1.745	1.755		1.753	1.751	1.750	1.750		
E	7.990	8.010		8.005	8.002	8.004	8.003		
F	0.490	0.510		0.501	.500	.497	.502		
G	0.257	0.262	DT8683	0.258	0.258	✓	✓		
H	0.375	0.380	DT8684	0.376	0.376	✓	✓		
I	0.490	0.510		0.508	.502	.499	.501		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		0.674	.511	.568	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.371	1.370	1.370		
N	2.495	2.505		2.500	2.501	2.500	2.500		
O	4.119	4.129		4.123	4.123	4.122	4.123		
P	0.115	0.135		0.125	.128	.128	.129		
Q	0.115	0.135		0.150	.133	.133	.128		
R	0.240	0.260		0.252	.250	.252	.248		
S	0.115	0.135		0.123	.126	.127	.125		
T	0.178	0.198		0.1875	.188	.188	.188		
U	3.210	3.250		3.230	3.231	3.233	3.232		
V	0.230	0.250		0.243	.244	.240	.239		
W	0.115	0.135		0.082	.132	.135	.128		
X	0.307	0.312			.312	.312	0.312		
Y	0.760	0.765			.760	.760	0.760		
Z	0.352	0.372		0.357	.371	.362	.364		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.632	.628	.628	.626		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.160	.250	.250	.248		
AE	1.500	1.520		1.514	1.511	1.512	1.511		
AF	0.115	0.135		0.125	.133	.133	.135		
AG	0.240	0.280		0.255	.260	.252	.269		
AH	0.240	0.260		0.248	.250	.250	.249		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043							
Accept/Reject				Reject					

Measured by:	M8 06/01/13	Audited by:	EP
Date:		Date:	06/01/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	✓		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.498	3.497	3.498	3.500		
D	1.745	1.755		1.750	1.750	1.748	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.005		
F	0.490	0.510		0.496	0.495	0.494	.503		
G	0.257	0.262	DT8683	0.258	0.258	0.258	✓		
H	0.375	0.380	DT8684	0.376	0.376	0.376	✓		
I	0.490	0.510		0.498	0.502	0.501	.504		
J	1.174	1.184		1.178	1.178	1.177	1.180		
K	0.558	0.578		0.567	0.569	0.570	.572		
L	1.174	1.184		1.177	1.177	1.177	1.180		
M	1.365	1.375		1.368	1.368	1.368	1.371		
N	2.495	2.505		2.498	2.497	2.499	2.501		
O	4.119	4.129		4.120	4.121	4.120	4.124		
P	0.115	0.135		0.127	0.126	0.126	.127		
Q	0.115	0.135		0.127	0.133	0.125	.135		
R	0.240	0.260		0.252	0.251	0.249	.249		
S	0.115	0.135		0.127	0.126	0.126	.126		
T	0.178	0.198		0.190	0.190	0.190	.188		
U	3.210	3.250		3.231	3.233	3.234	3.236		
V	0.230	0.250		0.239	0.239	0.239	.240		
W	0.115	0.135		0.128	0.122	0.126	.125		
X	0.307	0.312		0.312	0.312	0.312	.312		
Y	0.760	0.765		0.760	0.760	0.760	.760		
Z	0.352	0.372		0.362	0.360	0.350	.360		
AA	0.470	0.530		0.500	0.500	0.500	.500		
AB	0.615	0.635		0.627	0.630	0.626	.627		
AC	0.053	0.073		0.063	0.063	0.063	.063		
AD	0.240	0.260		0.246	0.246	0.245	.250		
AE	1.500	1.520		1.511	1.508	1.510	1.510		
AF	0.115	0.135		0.133	0.132	0.133	.135		
AG	0.240	0.280		0.260	0.261	0.260	.275		
AH	0.240	0.260		0.250	0.250	0.249	.250		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.033	.030		
Accept/Reject									

Measured by:	MS 06/01/12	Audited by:	ED
Date:		Date:	06/01/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	24840
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. D and record values

				Recorded Actual Dimensions			
Dim	Min	Max	Go/No Go Gauge	1	2	3	4
A	0.438	0.443	DT8682	✓	✓	✓	✓
B	1.745	1.755		1.752	1.751	1.751	1.751
C	3.495	3.505		3.500	3.501	3.500	3.500
D	1.745	1.755		1.752	1.751	1.751	1.751
E	7.990	8.010		8.002	8.002	8.004	8.002
F	0.490	0.510		.502	.501	.502	.505
G	0.257	0.262	DT8683	✓	✓	✓	✓
H	0.375	0.380	DT8684	✓	✓	✓	✓
I	0.490	0.510		.497	.500	.504	.501
J	1.174	1.184		1.171	1.171	1.171	1.171
K	0.558	0.578		.569	.570	.572	.571
L	1.174	1.184		1.171	1.171	1.171	1.171
M	1.365	1.375		1.370	1.369	1.371	1.370
N	2.495	2.505		2.500	2.500	2.500	2.500
O	4.119	4.129		4.122	4.122	4.123	4.123
P	0.115	0.135		.124	.127	.124	.128
Q	0.115	0.135		.135	.135	.135	.135
R	0.240	0.260		.250	.250	.246	.248
S	0.115	0.135		.122	.124	.120	.124
T	0.178	0.198		.188	.188	.188	.188
U	3.210	3.250		3.235	3.231	3.232	3.233
V	0.230	0.250		.240	.240	.236	.242
W	0.115	0.135		.128	.126	.125	.126
X	0.307	0.312		.311	.311	.311	.311
Y	0.760	0.765		.762	.762	.762	.762
Z	0.352	0.372		.361	.359	.362	.360
AA	0.470	0.530		.500	.500	.500	.500
AB	0.615	0.635		.629	.628	.627	.629
AC	0.053	0.073		.063	.063	.063	.063
AD	0.240	0.260		.246	.250	.245	.250
AE	1.500	1.520		1.511	1.511	1.511	1.511
AF	0.115	0.135		.135	.135	.130	.135
AG	0.240	0.280		.275	.275	.275	.270
AH	0.240	0.260		.247	.250	.242	.248
AI	2.000	2.020		N/A	N/A	N/A	N/A
Accept/Reject							

Measured by:	MS
Date:	06/01/13

Audited by:	ES
Date:	06/01/13

Rev	Date	Change	Revised by
A		New Issue	RF
B	02.09.27	Re format; Added Rev. D	KJ
C	02.10.11	Re format; Added DT8682, DT8683, DT8684	KJ
D	05.05.05	Added dimension AI	KJ/RT

DART AEROSPACE LTD		Work Order: 24840
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓					
B	1.745	1.755		1.750					
C	3.495	3.505		3.500					
D	1.745	1.755		1.750					
E	7.990	8.010		8.002					
F	0.490	0.510		.502					
G	0.257	0.262	DT8683	✓					
H	0.375	0.380	DT8684	✓					
I	0.490	0.510		.501					
J	1.174	1.184		1.178					
K	0.558	0.578		.572					
L	1.174	1.184		1.178					
M	1.365	1.375		1.370					
N	2.495	2.505		2.500					
O	4.119	4.129		4.122					
P	0.115	0.135		.126					
Q	0.115	0.135		.135					
R	0.240	0.260		.126					
S	0.115	0.135		.125					
T	0.178	0.198		.188					
U	3.210	3.250		3.231					
V	0.230	0.250		.240					
W	0.115	0.135		.125					
X	0.307	0.312		.311					
Y	0.760	0.765		.762					
Z	0.352	0.372		.362					
AA	0.470	0.530		.500					
AB	0.615	0.635		.628					
AC	0.053	0.073		.063					
AD	0.240	0.260		.251					
AE	1.500	1.520		1.511					
AF	0.115	0.135		.135					
AG	0.240	0.280		.270					
AH	0.240	0.260		.250					
AI	2.000	2.020		N/A					
Accept/Reject									

Measured by:	MS
Date:	06/01/13

Audited by:	Er
Date:	06/01/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	77

RELEASED
05.05.05

